

5/12

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>22475</b>
<b>Description:</b> Wheel Shaft	<b>Part Number:</b>	<b>D3334-1</b>
<b>Dwg:</b> D3334 Rev. A	<b>Qty:</b>	<b>12</b>
Page 1 of 1		

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	CP	05.03.03	12
2	MS	Cut blanks: Ø3.500" Bar to 7.750" long Material: AISI 4140 or ASTM A304-02/A-434-BC/A193-03-Grade-B7/A29-03/A322-91 or UNS# G41400 (M4140H-R3.500) <b>Identify for D3334-1</b> Batch: <u>M16800</u>	CP	05/03/03	12
3	MS	Turn as per Folio FA492 and Dwg D3334	EP	05/03/03	12
4	QC2	Inspect parts as they come off the CNC machine	EP	05/03/03	12
5	MS	Deburr	EP	05/03/03	12
6	MV	Machine as per Folio FA492 and Dwg D3334 <b>Identify as D3334-1</b>	JL	05/03/15	12
7	QC2	Inspect parts as they come off the CNC machine	JL	05/03/15	12
8	QC8	Second check	EP	05.03.15	12
9	QC5	Inspect work to step 8.	EP	05.03.15	12
10	FP	Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3 <b>Mask thread and bearing surface</b>	ML	05.04.04	12
11	QC3	Inspect Powder Coat	U	05.04.12	12
12	ST	Identify and Stock	CL	05/04/12	12
13	AC	Cost / part: <u>97.13</u>	SUE	05.04.12	12
14	DC	Close W/O <u>97.13</u> Inspect Level 21	CP	05.04.18	12

Rev	Date	Change	Revised By	Approved
A	05.01.13	New issue	KJ/JLM	
B	05.03.02	Revised material; Added Powder Coat	KJ/JLM	

RELEASED  
11/05/03

196.85

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR: 22475		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05/03/08	#3	one part over thread tool upside down <del>found</del> Two parts scrap Tail stall out of glue.	18 050308	destroy & replace Six Solis	18 050315	18 050309	18 050309	
05-03-15	#3	Two parts are over- tol. on shaft should be 1.180 $\pm 0.002$ reading 1.181 - 1.1793	18 050315	ok this one time	18 050315	18 050315	18 050315	

Part No: D3334-1 PAR #: \_\_\_\_\_ Fault Category: Prod/machine NCR: Yes ☒ No ☐ DQA: 18 Date: 05/04/15

NOTE: Date & initial all entries QA: N/C Closed: 18 Date: 05.04.15

DART AEROSPACE LTD		Work Order:	22475
Description:		Part Number:	D3334-1
Inspection Dwg:	Rev:	Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☐

First Article

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Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.060	$\pm 0.010$	3.061	✓		vern	milling
1.530	$\pm 0.010$	1.530	✓		vern	milling
Ø 0.386	$\pm 0.010$	.387	✓		vern	milling
2.250	$\pm 0.010$	2.248	✓		vern	milling
1.125	$\pm 0.010$					milling
3.470	$\pm 0.010$	3.462	✓		mic	lathe
1.300	$\pm 0.010$	1.298	✓		vern	milling
0.650	$\pm 0.010$					milling
0.045 x 45°	$\pm 0.010$	0.045 x 45°	—			lathe
0.200	$\pm 0.010$	0.204	—			milling
0.940	$\pm 0.030$	0.934	—			
4.740	$\pm 0.030$	4.737	—			
1.04	$\pm 0.030$	1.040	—			
Ø 0.750	$\pm 0.010$	0.750	—			
7.468	$\pm 0.010$	7.468	—			bright ground
R. 0.063	$\pm 0.010$	0.063	—			
1.750	$\pm 0.010$	1.749	—			
R. 0.125	$\pm 0.010$	0.125	—			
1.180	$\pm 0.002$	1.180	—			
1.004/1.000		1.010	—			measure for wire
0.9983/0.998	0.982	0.996	—			

can't measure

can't measure

Measured by: J.L. / EP	Audited by: JML	Prototype Approval: <input checked="" type="checkbox"/>
Date: 05-03-09	Date: 05/03/09	Date: 05.03.15

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	

# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Feb 15, 2005  
02:56 pm

Work Order No : 0022475  
Project Name : D3334-1  
Project For : WK512  
Work Order Type : Main  
Main WO Number :  
House Part Number : D3334-1  
Description : Wheel Shaft  
Manufactured : Yes  
Amount Req'd : 12  
Amount Done : 0  
Start Date : 02-15-05  
Est Finish Date : 03-10-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

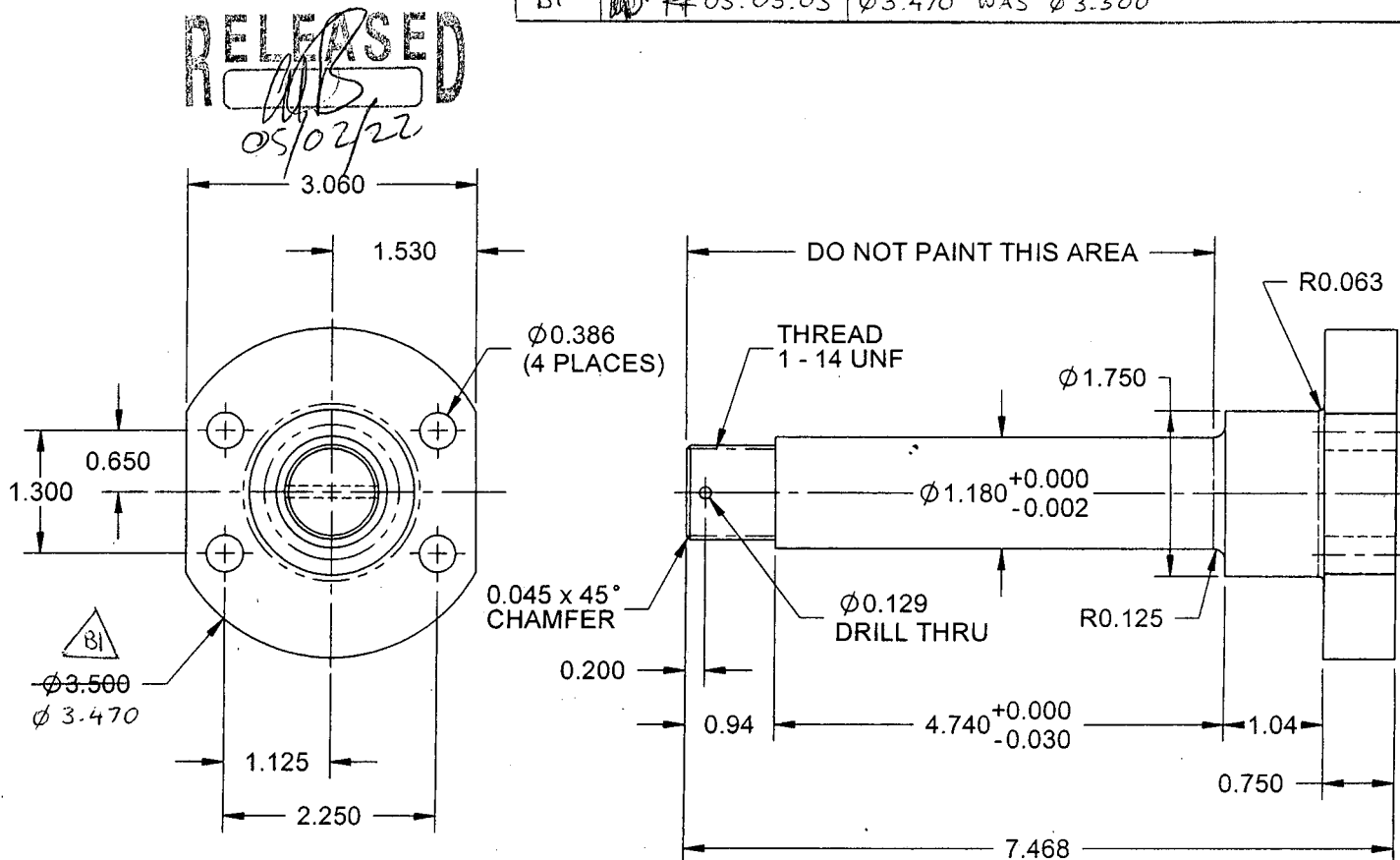
Department Code :  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Margin : 0.0000%  
Actual Margin : 0.0000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3334	REV. B SHEET 1 OF 1
DATE 05.02.18		TITLE WHEEL SHAFT	SCALE 1:2
A	04.12.16	NEW ISSUE	
B	05.02.18	REDESIGN TO FIT NEW WHEEL ASS'Y	
BI	05.03.03	Ø3.470 WAS Ø3.500	



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WITHOUT NOTICE

WORK ORDER  
NO. 22775

**D3334-1 WHEEL SHAFT**

**NOTES:**

- 1) MATERIAL: AISI-4140 OR ASTM A304-02/ A-434-BC/ A193-03-GRADE-B7/ A29-03/ A322-91 OR UNS#-G41400 (REF. DART SPEC. M4140H-R3.500)
- 2) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020

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